

Work Order ID 85182

Monday, June 04, 2012 11:09:38 AM

85182

ASAP

Page 1

Item ID: PB67-43001-197

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Outer Tube

Start Date: 6/4/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/15/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*Date: *12-06-04* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut to length as per dwg

2- deburr

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes end holes using DT8792

2- Mill slot

3-Drill .125" holes

4-deburr

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*12-06-22**12-06-22**12-06-25*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85182***85182***

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00

130

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end cap as per dwg PB67-43001

2-grind end cap flush

Alum Rod # 120854

1 0

12.06.25

140

QC10- Inspect visual per QSI004- ground welds

0.00

140

QC

Memo

0.00

Quality Control

1x

12.06.25

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

1

12.06.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Item ID: PB67-43001-197

Revision ID:

Item Name: Outer Tube

Start Date: 6/4/2012 Start Qty: 1.00

Required Date: 6/15/2012 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

1X SP
12-6-2612/6/26 JJ
MF
12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 04, 2012 11:09:37 AM

Page 1

Work Order ID: 85182
 Parent Item: PB67-43001-197
 Parent Item Name: Outer Tube

Start Date: 6/4/2012 Required Date: 6/15/2012
 Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065 6061T6 RDTUBE 1.750 X 0.65W		Purchased	No			100	f	25.7484	4.1775	4.3973684			

Location Loc Qty Loc Code

MAT016 25.7484
 108551 2.71
 109397 2.6634
 110885 16
 111432 4.375

PB67-43001-199
 Outer Tube End Cap

Manufactured No

122146

130 Each 21.0000

4.4 12-06-22
 12-06-25

Location Loc Qty Loc Code

Mezz 21
 44991 21

1

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DART AEROSPACE LTD		Work Order: 85182
Description: Outer Tube		Part Number: PB67-43001
Inspection Dwg: PB67 -43001-197		Rev: C
		Page 1 of 1

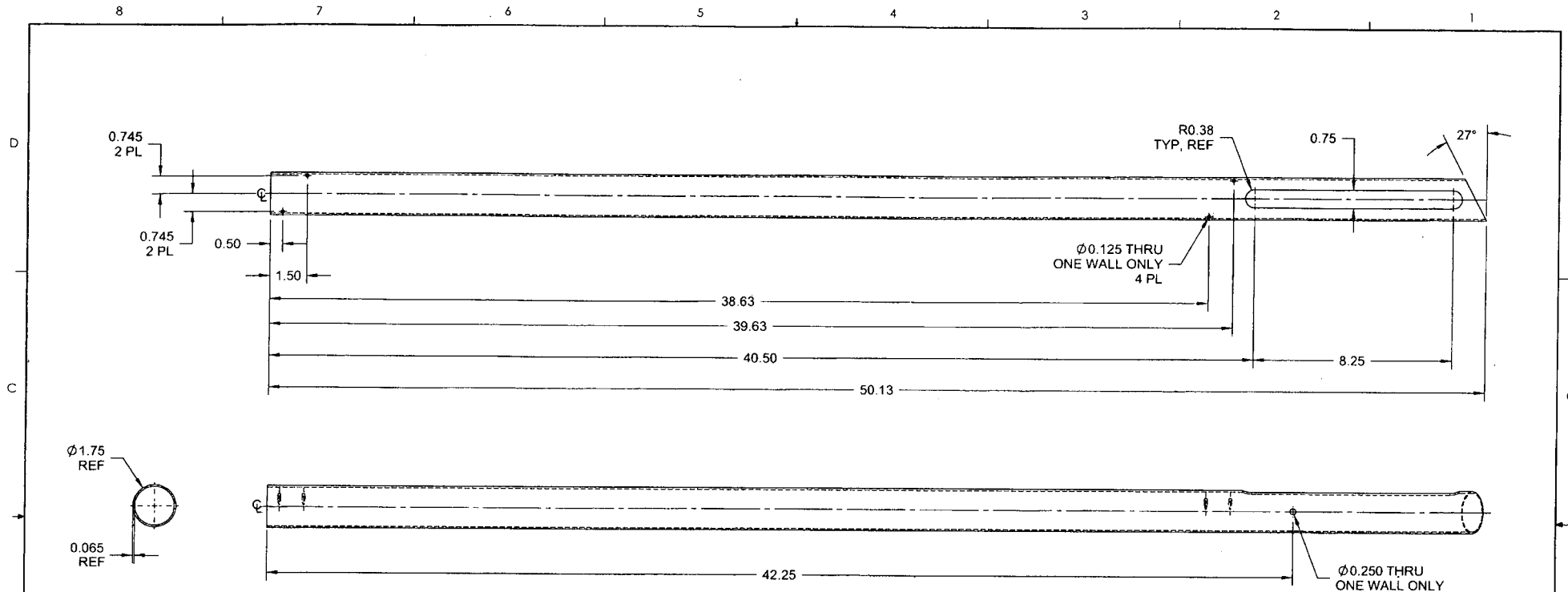
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
50.13	$\pm .030$	50.13	—		RA04	TAPE
40.50	$\pm .030$	40.50	—		"	
39.63	$\pm .030$	39.63	—		"	
38.63	$\pm .030$	38.65	—		"	
1.50	$\pm .030$	1.50	—		"	
150	$\pm .030$	150	—		"	
42.25	$\pm .030$	42.25	—		"	
Ø.250	$\pm .005$	Ø.251	—		RA26	Very
Ø.125	$\pm .004$	Ø.126	—		RA26	Very
.75	$\pm .030$.770	—		RA26	Very
8.25	$\pm .030$	8.25	—		RA04	
27°	$\pm \frac{1}{2}^\circ$	27°	—		CNC03	Angle Measure

Measured by: 	Audited by:	Preliminary Approval:
Date: 12-6-25	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15



B67-43001-197 OUTER TUBE

#85182

RELEASED
2009-09-24

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.62 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	B67-43001-197	REV. C
MFG. APPR.	AS	SHEET 1 OF 1		
APPROVED	AS	TITLE	OUTER TUBE	SCALE
DE APPR.	N/A	NTS		
DATE	09.02.27	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

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